



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3438-042
Job Sheet 174036



Part No: D3438-042

Job Qty: 2 ea

Part Name: Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/9/18

Job Tracking No:

Due Date: 3/21/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A IPP A 05.05.18 New Issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	3/20/18	3/20/18	0.00	0.00	Start Up Large Fab-4		CPC
100	Large Fab	2 pcs	3/20/18	3/20/18	0.00	2.56	Large Fab 2		CPC
110	QC	2 pcs	3/20/18	3/20/18	0.00	0.00	QC9		18-3-15
120	QC	2 pcs	3/20/18	3/20/18	0.00	0.00	QC5		18-3-15
130	HandFinish	2 pcs	3/20/18	3/20/18	0.00	0.97	HandFinish1		SA 18-3-16
140	QC	2 pcs	3/20/18	3/20/18	0.00	0.00	QC3		CA
150	Large Fab	2 pcs	3/20/18	3/20/18	0.00	2.56	Large Fab 2		18-3-16
160	QC	2 pcs	3/20/18	3/20/18	0.00	0.00	QC10		PD 18-3-23
170	QC	2 pcs	3/20/18	3/20/18	0.00	0.00	QC5		PD 18-3-23
175	HandFinish	2 pcs	3/20/18	3/20/18	0.00	0.20	HandFinish6		SA 18-3-24
180	Powdercoat	2 pcs	3/20/18	3/20/18	0.00	0.28	Powdercoat1		BR 18-3-26
190	HandFinish	2 pcs	3/21/18	3/21/18	0.00	0.97	HandFinish3		DEF 18-03-27
200	QC	2 pcs	3/21/18	3/21/18	0.00	0.00	QC3		38
210	Packaging	2 pcs	3/21/18	3/21/18	0.00	0.00	Packaging3-1		DAS 9-88
220	QC21-SA	2 Ea	3/21/18	3/21/18	0.00	0.00	QC21		21 MAR 7 2018

Part Op 100 - 1-Cut D2244 to 79.63" at 34° as per Dwg D3438 3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg Descriptions: D3438 using DT8343 4-Grind

150 - Weld last cap per dwg D3438 & grind flush

175 - Touch up alodine

180 - 1-Touch up alodine

190 - Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs

M 138760 START: 2:30 O.V.T: 3:00 FINISH: 3:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	B164533
D2561	Lug	4 Ea (2 ea)	90-Start up Operation	5008763
D2673-34	End Plate	4 Ea (2 ea)	90-Start up Operation	5042088
D2564	Mounting Angle	4 Ea (2 ea)	90-Start up Operation	5042481

wing walk M138711

001618

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	2	168	0
	D2561	4	20	0
	D2564	4	15	0
	D2673-34	4	19	0
Part Specifications				
Specifications could not be found.				

Plex 3/9/18 10:31 AM Dart.Gagnon.Michelle



Container No: S050748



Part: D3438 - 042

Job No: 174036

Serial No/Batch: S050748

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

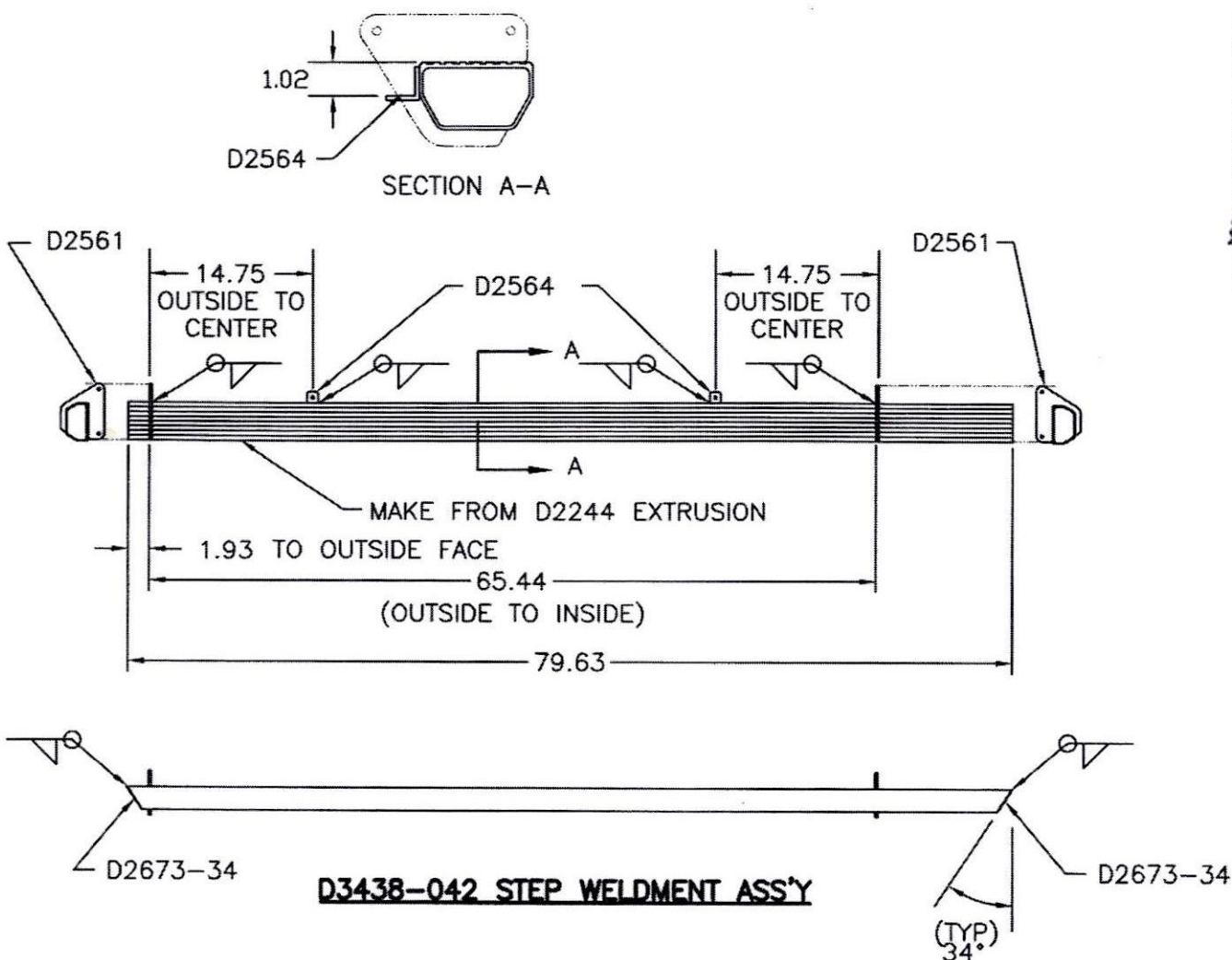
Date: 03/13/18

DART

RELEASED

05.05.27

DESIGN	DRAWN BY	DART AEROSPACE LTD	
RF	RF	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3438	SHEET 1 OF 1
DATE		TITLE	SCALE
05.05.09		STEP WELDMENT ASSEMBLY	1:1
A	05.05.09	NEW ISSUE	



NOTES:

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1 WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS